



Dart Aerospace Ltd.
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RBE350A93-3712-00

Job Sheet 195069



Part No: RBE350A93-3712-00

Job Qty: 1 pcs

Part Name: Main Rotor Swashplate Bearing Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 7/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 11876*

Note: DWG RBE350A93-3712-00 Rev A IPP Rev. A 19.04.25 New issue DP Verify DD

Ship Via:

Bill of Materials



Container No: S198506

Part: RBE350A93-3712-00

Job No: 195069

Serial No/Batch: S198506

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/17/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	7/2/19		0.00	0.20	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	7/2/19		0.00	0.00	QC 5 - 10		JUL 17 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68	DAS	
							QC 5 - 9	81	
							QC 5 - 50	9-89	
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	7/2/19		0.00	0.00	Packaging 3 - 1 - B4B		MLL
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	1 pcs	7/2/19		0.00	0.00	QC 21 - FG - 21		JUL 18 2019
							QC 21 - FG - 70	DAS	
							QC 21 - SA - 53	21	

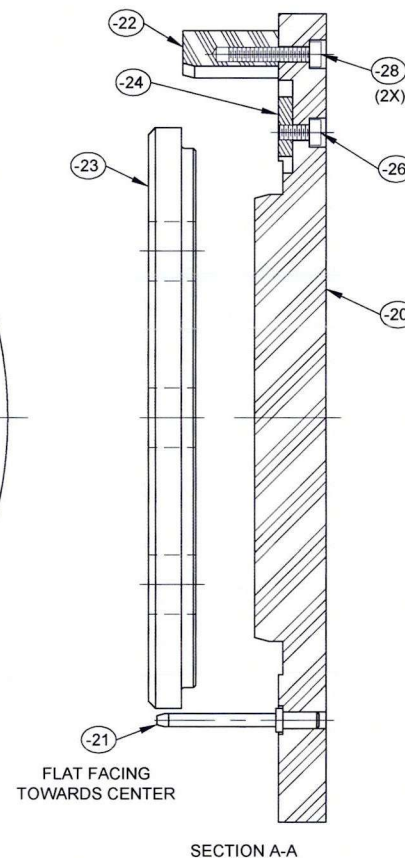
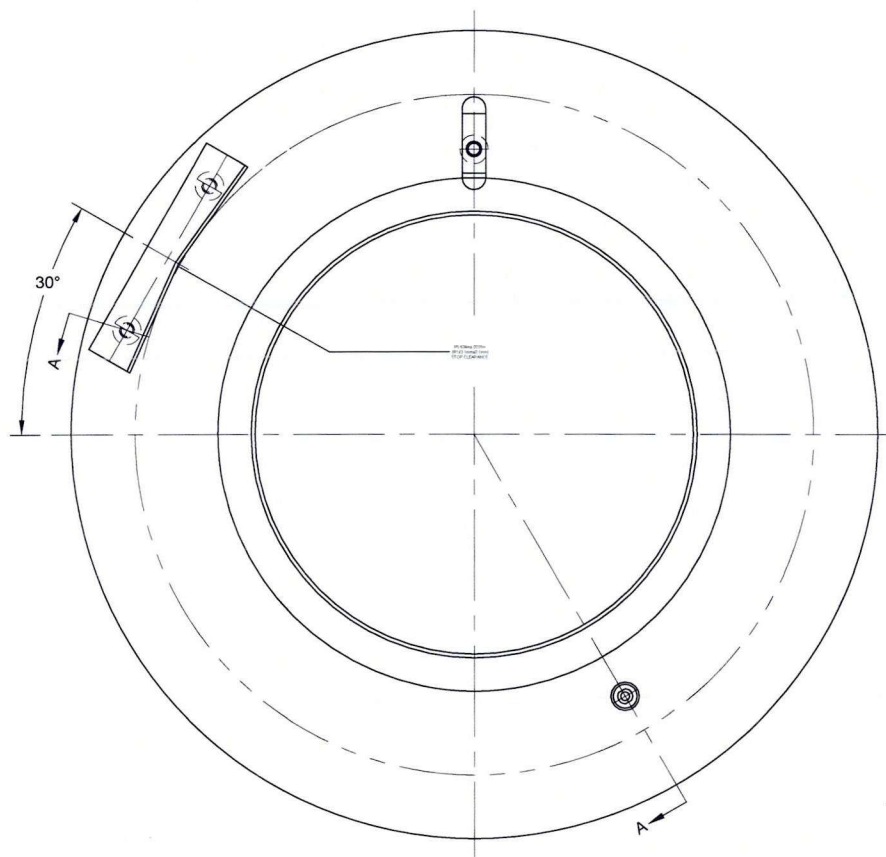
Part Op
Descriptions: 100 - Assemble as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
54 91290A318	Socket Head Cap Screw, M6 X 1 X 12	1 Ea (1 ea)	100-Small Fab - 1	318301A
66 91290A332	Screw, M6 X 30mm SHCS	2 Ea (2 ea)	100-Small Fab - 1	3144502
143 RBE350A93-3712-00-20	Pedestal	1 pcs (1 ea)	100-Small Fab - 1	3192254
141B RBE350A93-3712-00-21	Centering Pin	1 pcs (1 ea)	100-Small Fab - 1	3188477
143B RBE350A93-3712-00-22	Stop	1 pcs (1 ea)	100-Small Fab - 1	3190684
143 RBE350A93-3712-00-23	Top Plate	1 pcs (1 ea)	100-Small Fab - 1	3190690
143 RBE350A93-3712-00-24	Mount	1 pcs (1 ea)	100-Small Fab - 1	3185211

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91290A318	1	0	0
	91290A332	2	42	0
	RBE350A93-3712-00-20	1	0	0
	RBE350A93-3712-00-21	1	0	0
	RBE350A93-3712-00-22	1	0	0
	RBE350A93-3712-00-23	1	0	0
	RBE350A93-3712-00-24	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 5/13/19 3:16 PM Dart.lajeunesse.marie



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195069 M.C.S
19-05-14

NOTE:
1. REF. EUROCOPTER T/N:
350A93-3712-00

TITLE		RED BARN MACHINE	
TITLE		ASSEMBLY SUPPORT FIXTURE	
DWG NO.	RBE350A93-3712-00		REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY PERRITT	
TOLERANCES ON:		APPROVED <i>D. Med</i>	
DECIMALS IN:		BEST	
XXX ± .0039		TREAT	
XX ± .01		FINISH	
X ± .1		SPEC	
ANGLES ± 5°		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED		EUROCOPTER E350A	
1. BREAK ALL SHARP EDGES		1 OF 6	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SHEET	
SCALE	1:2	DATE	12-21-09

ASSY QTY	BO	PART #	QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-20	1	PEDESTAL	6061	Ø13-1/2 x 1-1/4	2
		-21	1	CENTERING PIN	4140	Ø1/2 x 2-7/8	3
		-22	1	STOP	6061	1 x 1-3/4 x 4	4
		-23	1	TOP PLATE	6061	Ø9-3/4 x 1	5
		-24	1	MOUNT	4140	1/4 x 1/2 x 1-1/8	6
		-26	1	SOCKET HEAD CAP SCREW	STEEL BLACK	M6x1 x 12	1
		-28	2	SOCKET HEAD CAP SCREW	STEEL BLACK	M6x1 x 30	1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			